

Work Order ID 59413

Friday, June 04, 2010 8:57:17 AM



Page 1

Item ID: D4020-11

Accept



Setup Start



Revision ID:

Item Name: End Mesh, Basket

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-6-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4020	A

100



FLOW WATER JET

Waterjet

Memo

0.00

1B 10-6-8

FLOW CNC Waterjet

I-Cut as per Dwg D4020
Dwg Rev: A
Prog Rev:
2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

1B 10-6-8

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

S w/o g los

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4020-11

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Setup Start



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Item Name: End Mesh, Basket

Stop



Start Date: 6/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/10/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: WTA

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

SAO 10-06-08

(6)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/09 JJ

10/06/08
(6)

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Picklist Print

Friday, June 04, 2010 8:57:22 AM

Page 1

Work Order ID: 59413



Parent Item: D4020-11



Parent Item Name: End Mesh, Basket

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F						100	sf	808.7532	2.694	17.01474			

Expanded Metal Flat SS



R10-6-8

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	808.7532	
114399	39.542	
114594	55.4855	114594
114744	213.7257	
114809	500	

(6)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59413
Description: End Mesh, Basket	Part Number:	D4020-11
Inspection Dwg: D4020 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	PB	Audited by:	S	Prototype Approval:	N/A
Date:	10-6-8	Date:	10/16/88	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	<i>[Signature]</i>

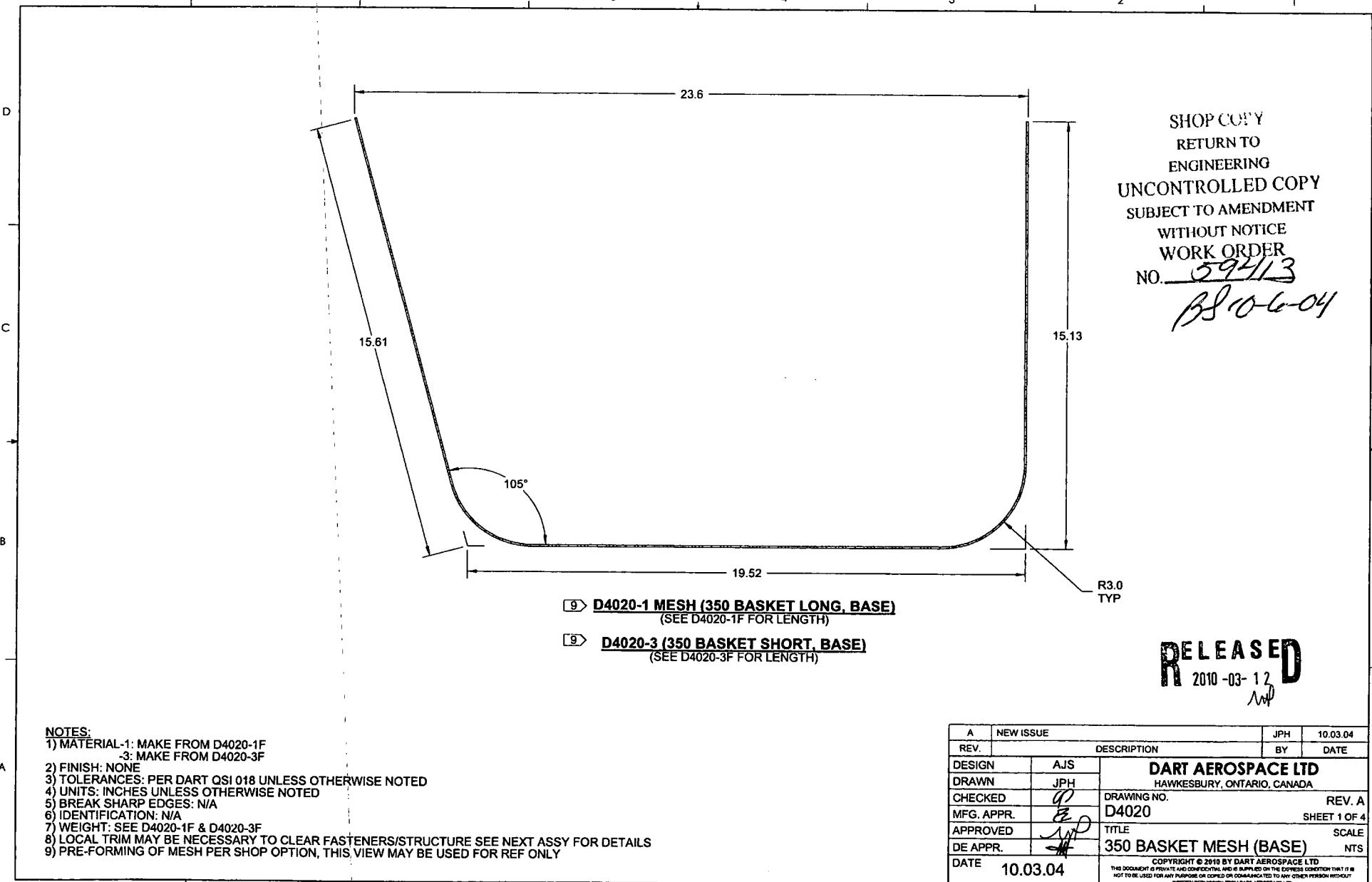
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

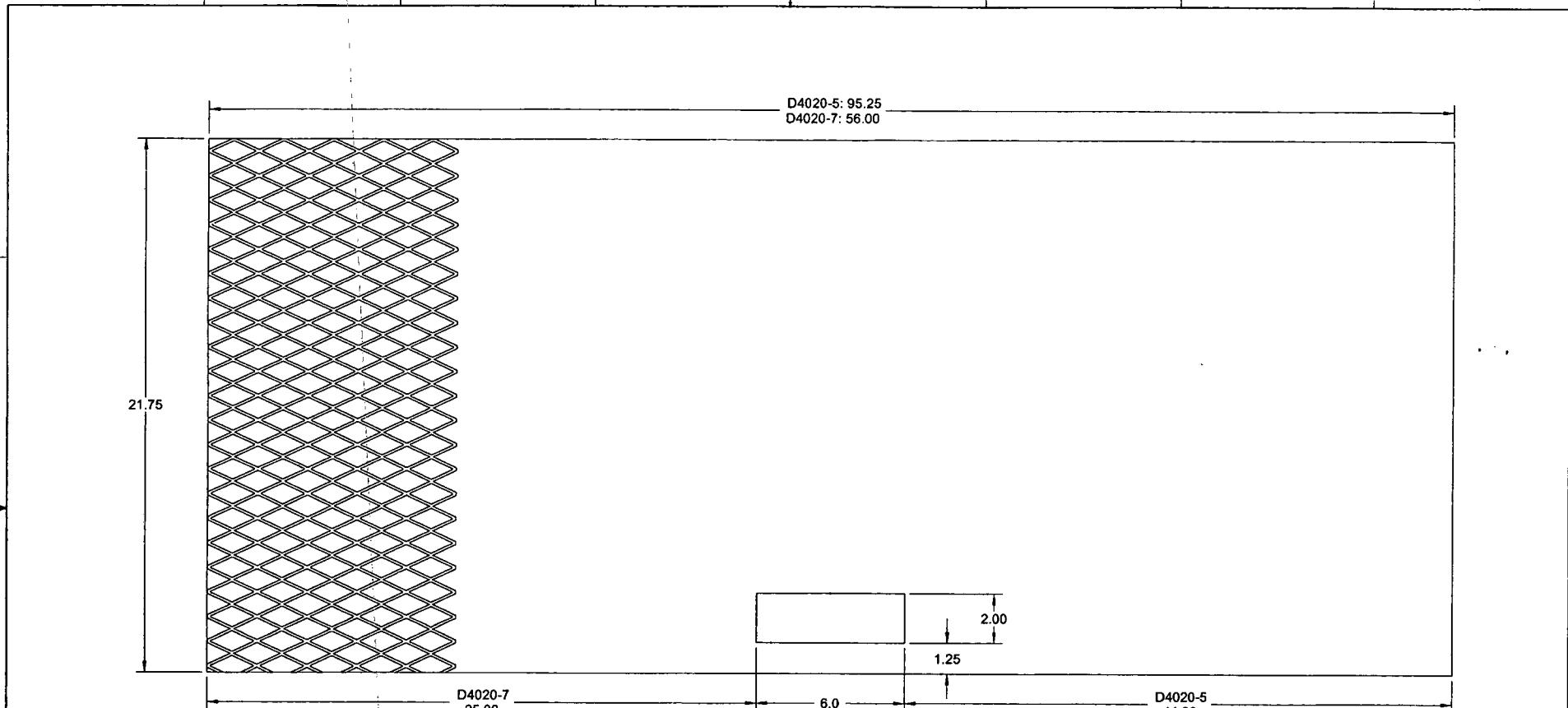
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8 7 6 5 4 3 2 1



⑨ D4020-5 MESH (350 BASKET LONG. LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

⑨ D4020-7 MESH (350 BASKET SHORT. LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS \pm 0.06.

WJD 39413

RELEASED
2010-03-12
MAD

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	W	DRAWING NO.
MFG. APPR.	B	REV. A
APPROVED	W	D4020
DE APPR.	W	SHEET 2 OF 4
DATE	10.03.04	TITLE
		350 BASKET MESH (BASE) NTS
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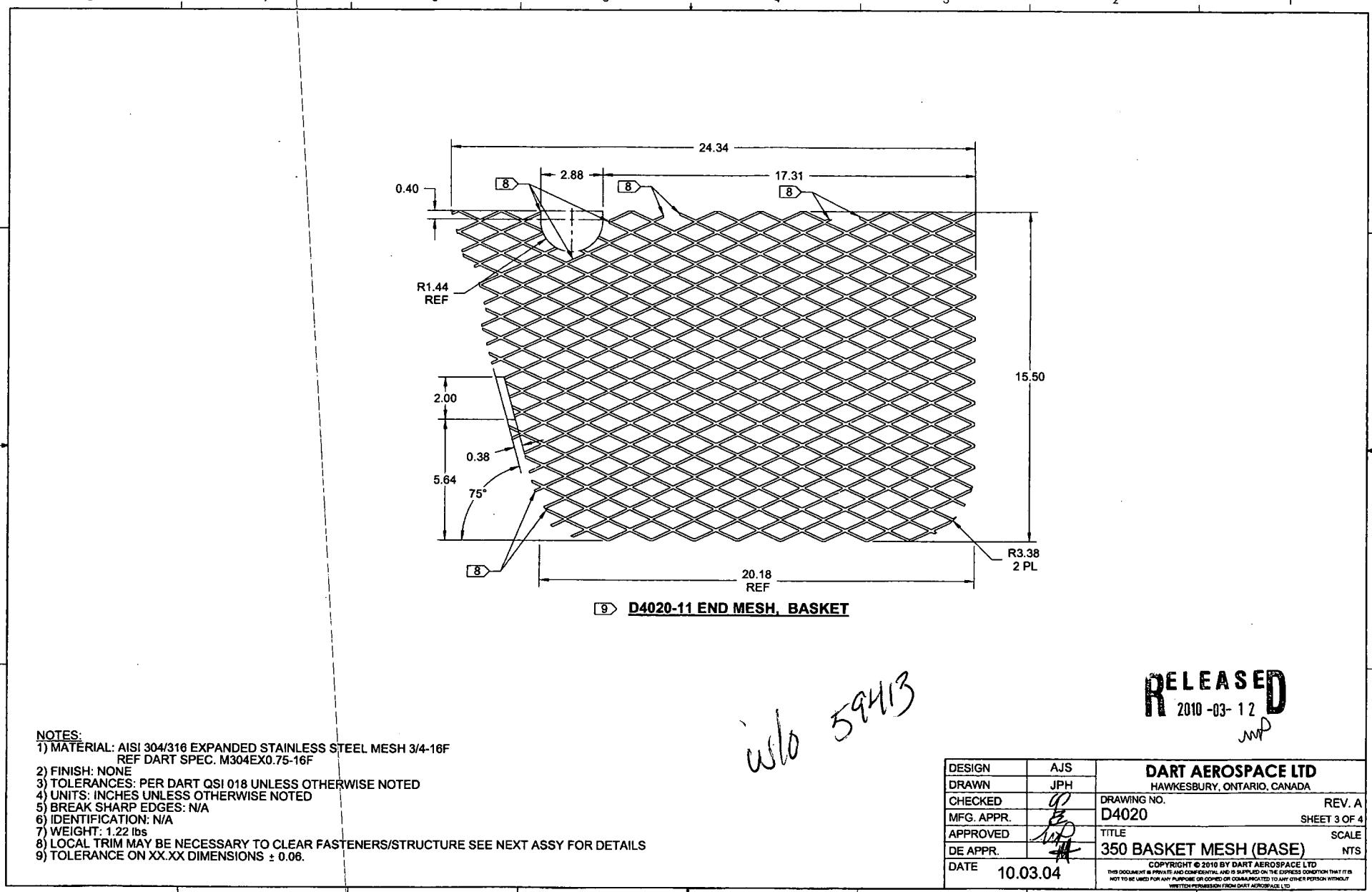
8 7 6 5 4 3 2 1

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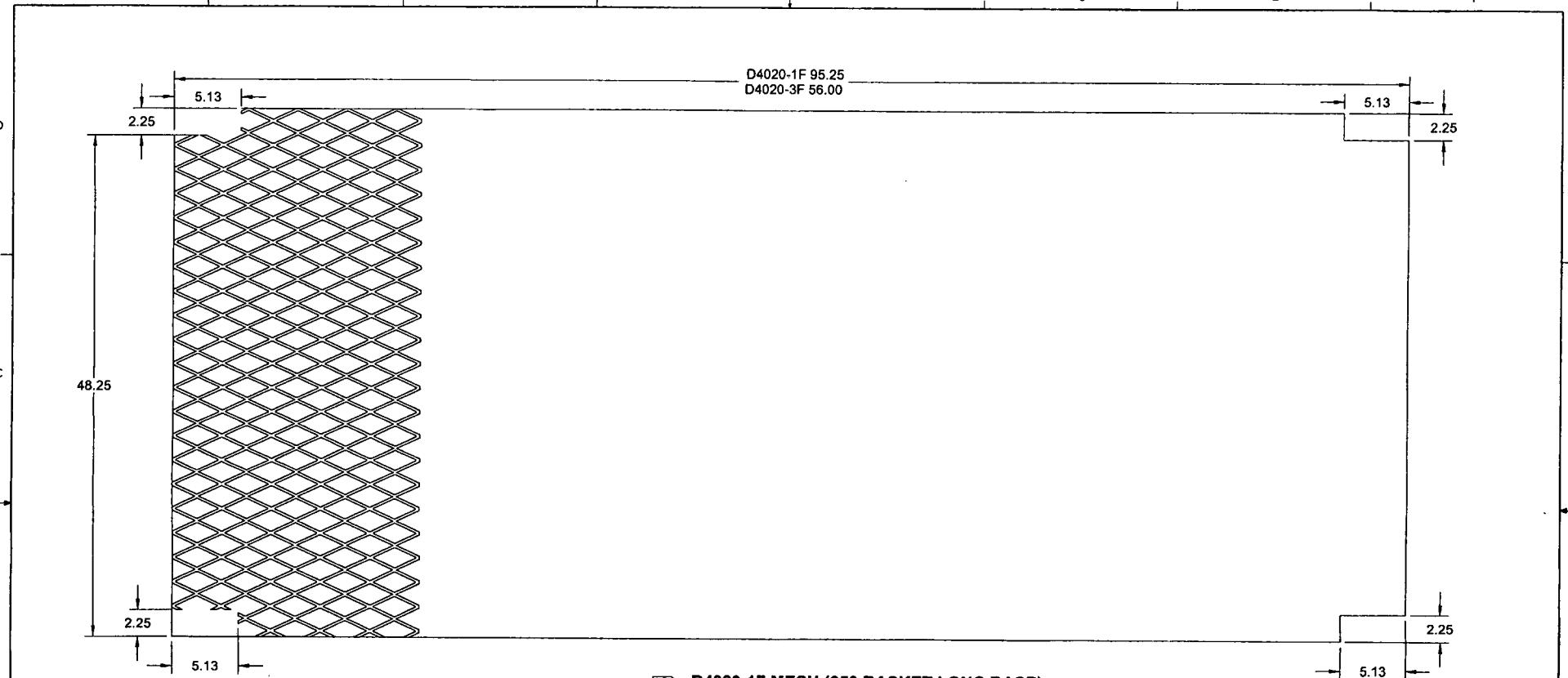
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8 7 6 5 4 3 2 1



⑧ **D4020-1F MESH (350 BASKET LONG BASE)**

(LOCAL SECTION MESH SHOWN FOR CLARITY)

⑧ **D4020-3F MESH (350 BASKET SHORT, BASE)**

(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-13
WJL 59413

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
- 8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

8 7 6 5 4 3 2 1

WJL 59413

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	JP	
MFG. APPR.	EP	REV. A
APPROVED	NP	DRAWING NO. D4020
DE APPR.	NP	SHEET 4 OF 4
DATE	10.03.04	TITLE 350 BASKET MESH (BASE)
		SCALE NTS
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